



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3910-3
Job Sheet 171074



Part No: D3910-3

Job Qty: 30 ea **35**

Part Name: Crosstube Lug



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/26/18

Job Tracking No:

Due Date: 2/28/18

Created By: Diane Baker

Type: Stock

Description:

Note: DWG REV E SHEETS 1,3 IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD IPP REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Purchasing	30 pcs		2/27/18	0.00	0.00	Purchasing		AT 18/02/01
120	Packaging	30 pcs		2/27/18	0.00	0.00	Packaging2		AT 18/02/01
130	QC	30 pcs		2/27/18	0.00	0.00	QC6		38 9-08
140	HandFinish	30 pcs		2/27/18	0.00	0.46	HandFinish1		
150	QC	30 pcs		2/27/18	0.00	0.00	QC7-3		
160	Powdercoat	30 pcs		2/28/18	0.00	0.26	Powdercoat1		
170	QC	30 pcs		2/28/18	0.00	0.00	QC3		
180	Packaging	30 pcs		2/28/18	0.00	0.00	Packaging3-2		
190	QC21-SA	30 Ea		2/28/18	0.00	0.00	QC21		

Part Op 110 - ISSUE PO TO METEC, NOTE ALODINE AND PAINT AS PER QSI 005
Descriptions: 120 - Ensure C of C is attach
160 - START TIME: _____

JAN 26 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2423	Lug Extrusion	3.7500 ft (.125 ea)	110-Purchasing	160522
D3910-3P	Crosstube Lug	30 pcs (1 ea)	110-Purchasing	

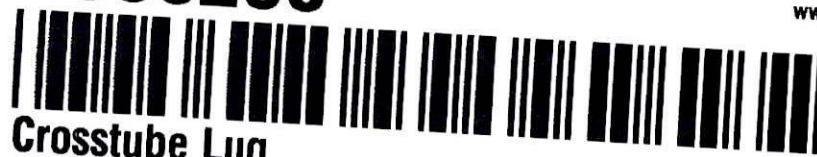
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Purchasing	D2423	4	829	0
	D3910-3P	30	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Crosstube Lug	4.450Inches $\pm$ 0.030	4.480 4.420		
2	Crosstube Lug	1.380Inches $\pm$ 0.030	1.410 1.350		
3	Crosstube Lug	0.080Inches $\pm$ 0.020	0.100 0.060	Radius	
4	Crosstube Lug	0.270Inches $\pm$ 0.030	0.300	reference	

DART
AEROSPACE
S038200



Crosstube Lug

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA

TEL.: 1 613 632-5200

Email: sales@dartaero.com
www.dartaerospace.com

PART NO: D3910-3
Original Serial #: S038200

Revision:

Operation:

Change No:

Purchasing

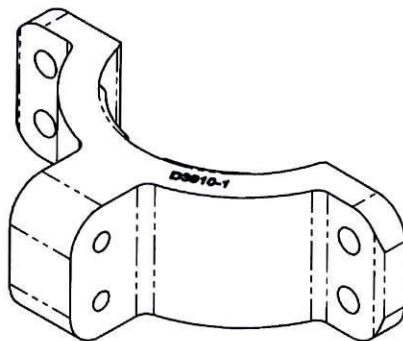
Mfg Date: 02/01/18

Job No: 171074

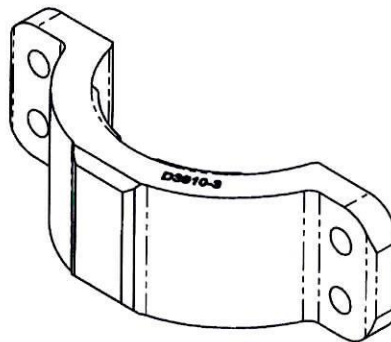
			0.240	
5	Crosstube Lug	0.310Inches ± 0.030	0.340 0.280	
6	Crosstube Lug	0.735Inches ± 0.010	0.745 0.725	reference
7	Crosstube Lug	1.200Inches ± 0.030	1.230 1.170	Radius
8	Crosstube Lug	3.700Inches ± 0.010	3.710 3.690	
9	Crosstube Lug	0.375Inches ± 0.010	0.385 0.365	
10	Crosstube Lug	0.625Inches ± 0.010	0.635 0.615	
11	Crosstube Lug	0.375Inches ± 0.010	0.385 0.365	
12	Crosstube Lug	0.340Inches ± 0.030	0.370 0.310	Radius
13	Crosstube Lug	0.257Inches + 0.006 - 0.001	0.263 0.256	Diameter
14	Crosstube Lug	0.100Inches ± 0.010	0.110 0.090	
15	Crosstube Lug	45.000Degrees ± 0.500	45.500 44.500	angle
16	Crosstube Lug	1.410Inches ± 0.030	1.440 1.380	Reference

Plex 1/26/18 1:35 PM Dart.baker.diane

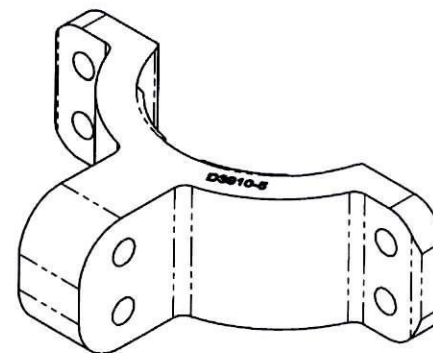




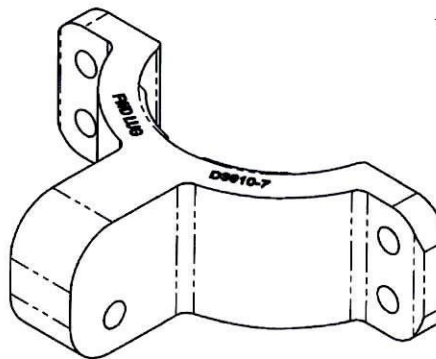
D3910-1 X-TUBE LUG



D3910-3 X-TUBE LUG



D3910-5 X-TUBE LUG



D3910-7 X-TUBE LUG

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 $\pm$ 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 $\pm$ 0.005
- 7) WEIGHT -1: 0.32 lbs
-3: 0.25 lbs
-5: 0.36 lbs
-7: 0.37 lbs
- 8) IDENTIFICATION: ENGRAVE "FWD LUG" TO A DEPTH OF 0.010 $\pm$ 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 $\pm$ 0.005

RELEASED

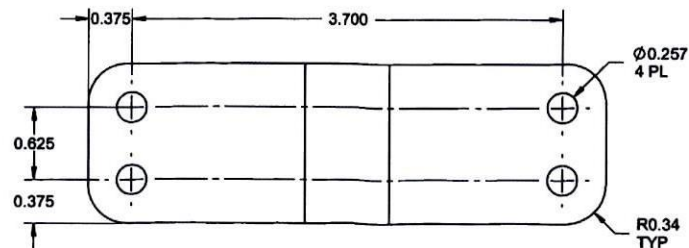
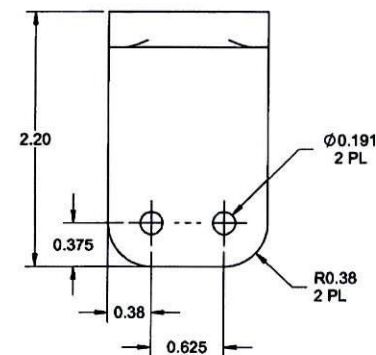
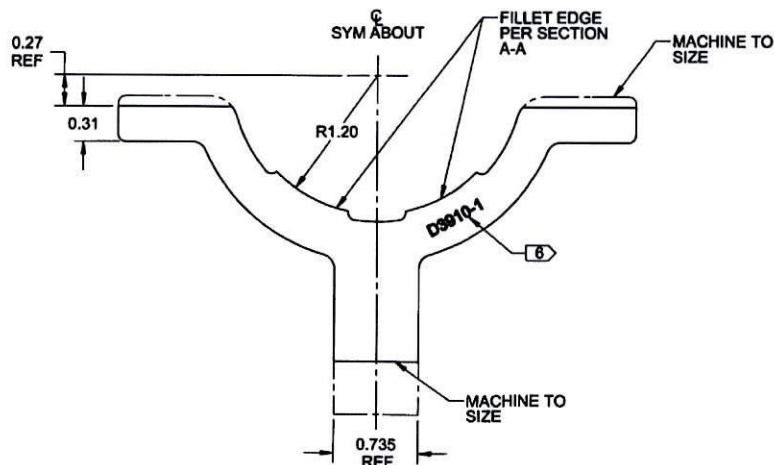
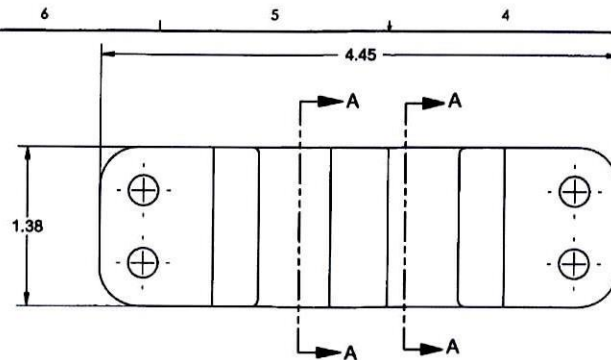
2014 JUN 05
ECN 14-572

E	ADD -7 PER NCR14-3871	AJS	14.05.16
D	CHANGED FASTENER HOLES IN -5 FOR 1/4" HARDWARE. REASON: EASE OF INSTALLATION.	AJS	13.08.14
C	ADD -5	AJS	13.08.08
B	Ø0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3). REASON: SEE TR-D390-807-2	JPH	10.03.16
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3910	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	X-TUBE LUG (350)	NTS
DATE	14.05.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



ROUND EDGE
R0.06 MIN - R0.10 MAX
2 PL

SECTION A-A



D3910-1 X-TUBE LUG

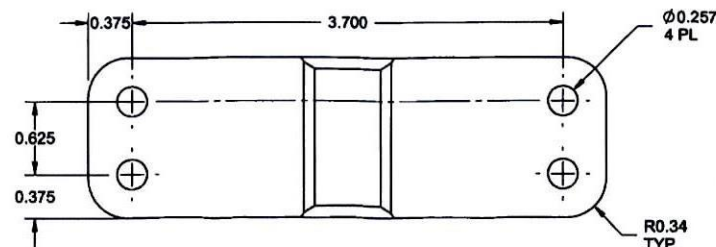
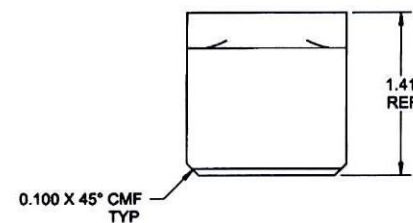
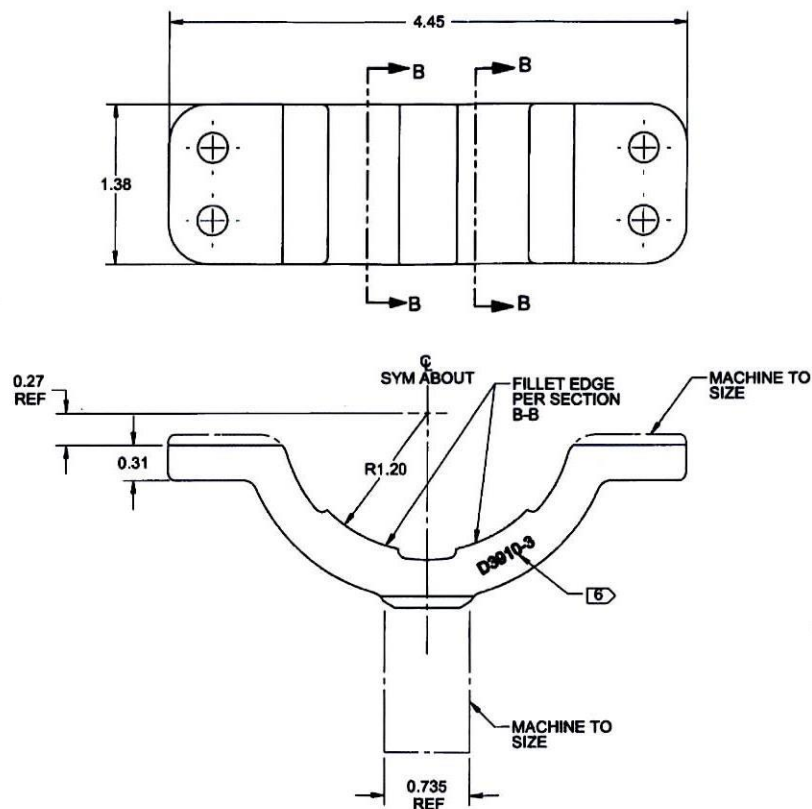
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2014 JUN 05 *q*

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3910	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	X-TUBE LUG (350)	NTS
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SECTION B-B



ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL



D3910-3 X-TUBE LUG

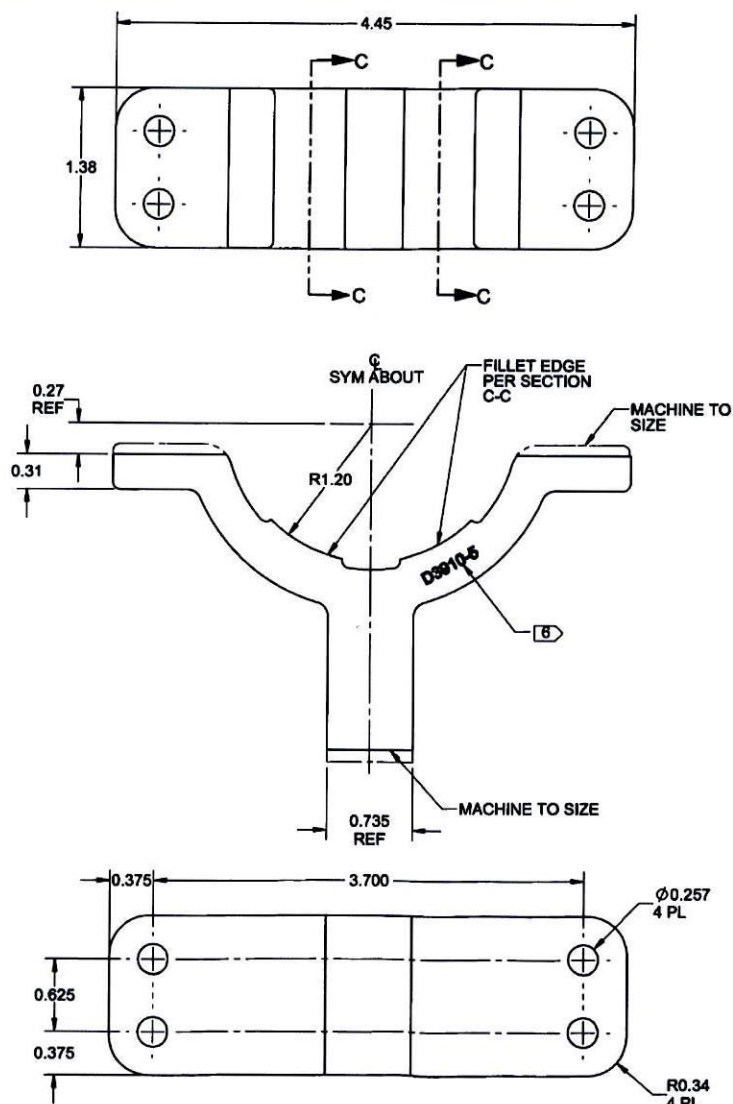
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2014 JUN 05

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3910	SHEET 3 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	X-TUBE LUG (350)	NTS
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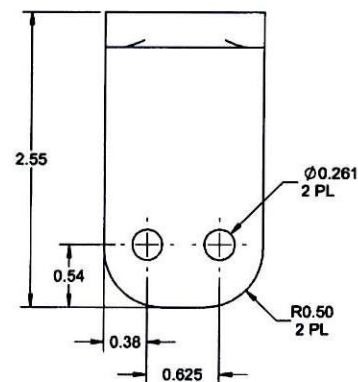
SECTION C-C



ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL



D3910-5 X-TUBE LUG



RELEASED
2014 JUN 05

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV.
MFG. APPR.		D3910	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG (350)	NTS
DATE	14.05.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO038884**

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO038884

PO Date: 1/26/18

Due Date: 2/2/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Baker, Diane
dbaker@dartaero.com

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

E-MAILED
JAN 29 2018

Items

Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	D2230-3P			Lug As Per Dwg D2230 Rev. G Alodine and Paint as per QSI005	Firmed	2/2/18	160 pcs ✓	0 pcs 160	160 pcs	\$13.80/pcs	\$2,208.00
Line Item Note job# 170990											
2	D3235-1P			Lug As Per Dwg D3235 Rev. A Alodine and Paint as per QS I005	Firmed	2/2/18	42 pcs ✓	0 pcs 42x	42 pcs	\$15.00/pcs	\$630.00
Line Item Note job# 170998											
3	D2230-1P			Lug As Per Dwg D2230 Rev. G Alodine and Paint as per QSI 005	Firmed	2/2/18	10 pcs ✓	0 pcs 10x	10 pcs	\$16.10/pcs	\$161.00
4	D3910-1P			Crosstube Lug As Per Dwg D3910 Rev. E Alodine and Paint as pe QSI 005	Firmed	2/2/18	20 pcs ✓	0 pcs 20x	20 pcs	\$16.10/pcs	\$322.00
Line Item Note job# 171073											
5	D3910-3P			Crosstube Lug As Per Dwg D3910 Rev. E Alodine and Paint as Per QSI 005	Firmed	2/2/18	35 pcs ✓	0 pcs 35x	35 pcs	\$16.10/pcs	\$563.50
Line Item Note job# 171074											
6	D3910-7P			Crosstube Lug As Per Dwg. D3910 Rev. E Alodine and Paint as Per QSI 005	Firmed	2/2/18	20 pcs ✓	0 pcs 20x	20 pcs	\$16.10/pcs	\$322.00
Line Item Note job# 171075											



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038884

Items											
Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
7	D2230-3P			Lug As Per Dwg D2230 Rev. G Alodine and Paint as per QSI005	Firmed	2/23/18	80 pcs	0 pcs	80 pcs	\$13.80/pcs	\$1,104.00
Line Item Note job# 171142											
8	D3235-1P			Lug As Per Dwg D3235 Rev. A Alodine and Paint as per QS I005	Firmed	2/23/18	58 pcs	0 pcs	58 pcs	\$15.00/pcs	\$870.00
Line Item Note job# 171144											
9	D2230-1P			Lug As Per Dwg D2230 Rev. G Alodine and Paint as per QSI 005	Firmed	2/23/18	90 pcs	0 pcs	90 pcs	\$16.10/pcs	\$1,449.00
Line Item Note job# 171145											
										Grand Total:	\$7,629.50

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

ag
P.B.

Plex 1/29/18 2:30 PM dart.baker.diane



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
160	D2230-3	Mounting Lug Paint Batch # 21567 / Material Batch # 160522	38884
42	D3235-1	Mounting Lug Paint Batch # 21566 / Material Batch # 160522	38884
10	D2230-1	Mounting Lug Paint Batch # 21597 / Material Batch # 160522	38884
35	D3910-3	Crosstube Lug Paint Batch # 21207 / Material Batch # 160522	38884
20	D3910-7	Crosstube Lug Paint Batch # 20366 / Material Batch # 131451	38884
20	D3910-1	Crosstube Lug Paint Batch #21566 / Material Batch # 160522	38884

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Heather Nixon

Vankleek Hill, January 29, 2018